

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020167**Date Inspected:** 14-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations relative to the work being performed.

OBG Segment Name: 5BE+5CE / (Lift 5E) Trial Assembly

This Caltrans QA inspector observed Shielded Metal Arc Welding (SMAW) in progress. Welders are identified as #20108 & 048047 welding critical weld repair (CWR) #1056 and CWR #1075 in the 2G position using welding procedure specification WPS-345-SMAW-2G(2F)-FCM-Repair-1. The weld is identified as CA020-004. ZPMC Quality Control (QC) inspector is identified as Mr. Zhang Qing and certified welding inspector (CWI); Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 5BW / (Lift 5W) Trial Assembly

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #054467 welding CWR #1074 in the 1G position using welding procedure specification WPS-345-SMAW-1G(1F)-FCM-Repair-1. The welds are identified as SEG025A-008 and SEG023-005. ZPMC QC inspector is identified as Mr. Feng Ya Jun and CWI, Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the WPS.

OBG Segment Name: 6BE / Trial Assembly

This Caltrans QA inspector observed SMAW in progress. Welder is identified as #048659 welding WR #9695 in the 3G position using welding procedure specification WPS-345-SMAW-3G(3F)-FCM-Repair-1. The weld is identified as SEG030B-011. ZPMC QC inspector is identified as Mr. Wang Li Yang and CWI, Mr. Wu Zhi Cheng. The welding variables recorded by QC appeared to comply with the WPS.

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## WELDING INSPECTION REPORT

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OBG Segment Name: 8BE / Blast Shop 1

This QA Inspector performed ZPMC Notification of Inspection Request #2508. QA performed preliminary random visual inspection after the grit blast of the upper interior surfaces. From transverse weld seam to PP65 of this segment. Areas of visual weld and base metal defects that will require welding were taped and will be repaired to painting. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

“As noted within the contents of this report.”

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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